

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010304**Date Inspected:** 07-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Chen Ying Xin.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Amit K. Juvekar, was present during the times noted above for observations relative to the work being performed.

This QA Inspector observed the following work in progress:

Bay 10, North Tower, Struts.

SMAW welding of weld joint ND1-A6002-6-38, 40; located on Bay 10, North Tower. Welders are identified as 066443, 066155; ZPMC Quality Control Inspector (QC) is identified as Chen Ying Xin. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-4113-1.

Bay 11, East Tower, Lift 5, Skin B.

SAW welding of weld joint ESD1-TL5-2E/F-23A; located on Bay 11, East tower. Welders are identified as 041716; ZPMC Quality Control Inspector (QC) is identified as Zhan Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3221-B-U3C-S-1.

Bay 11, West Tower, Lift 5, Skin B.

SAW welding of weld joint WSD1-TL5-2L/F-9A; located on Bay 11, East tower. Welders are identified as 044560; ZPMC Quality Control Inspector (QC) is identified as Zhan Bo. The welding variables recorded by Quality Control Inspector (QC) appeared to comply with the Applicable WPS: WPS-B-T-3221-B-U3C-S-1.

Bay 10, North Tower, Corner Angle Plate Repair.

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Repair gouge out noticed on Corner Angle Plate weld Identified as SD1-A6002-1-9B. see attached picture for details.

Bay 11, West Tower, Lift 1.

Installing Exterior Splice Plate on Skin A & E.

This QA Inspector carried out NDE on following

Bay 10, Tower Strut, Repair UT.

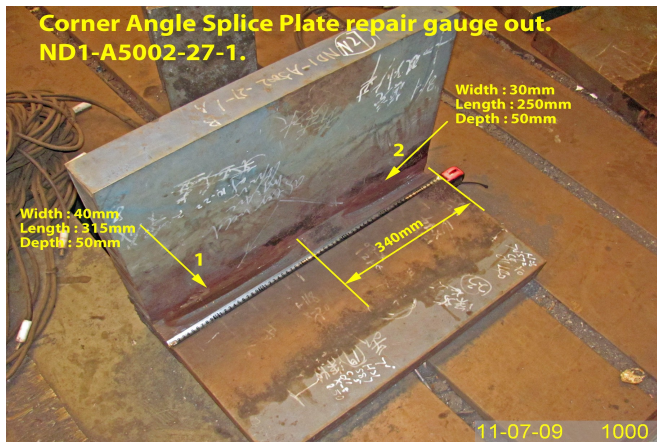
This QA inspector performs Random Ultrasonic Testing (UT) of repair area previously tested and accepted by ZPMC Quality Control personnel, FOR GREEN TAG. This QA Inspector generated an UT report(TL-6027) for this date. The members are identified as WD1-A6003-2.

This QA inspector found Class C unacceptable indication of length approximately 22mm. ZPMC agreed to Repair it & renotify for repair Ultrasonic Testing (UT). No incident report written on this issue.

Bay 10, East Tower, Lift 1, Skin A, B, C Stiffener to Base plate .

This QA inspector performs Random Visual Testing (VT), Magnetic Particle Testing (MT) of approximately 15% area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report (TL-6028) for this date. The members are identified as ESD1-A167B/H-6, 7, 12, 14 TO 21, 26 TO 29, 34 TO 37, 39, 128, 130, 132, 42, 47, 48, 55 TO 63, 71, 72.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 13482570045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Juvekar,Amit	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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